

November-25-11 10:54:31 AM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 25/11/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 09/12/2011 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/25

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

100	BAND SAW	0.00	
100			
Bandsaw	Memo	0.00	
Jeaspa Bandsaw	Cut blank 7.300" long		
			4
110	DOOSAN LATHE	0.00	
110			
Doosan	Memo	0.00	
Doosan Lathe	1-Turn as per folio FA 683 & DWG D3606, FOLIO REV: <u>01/1</u> DWG		
	REV: <u>B</u> 2-Deburr as required		
			4
120	QC2- Inspect parts off machine FAI/FAIB	0.00	
120			
QC	Memo	0.00	
Quality Control			
			4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77092

77092

Page 2

November-25-11 10:54:31 AM

Item ID: D3606-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cuff
 Start Date: 25/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00

130

QC Memo 0.00

Quality Control

140 Chemical Conversion Coat per QS1005 4.1 0.00

140

HandFinish Memo 0.00

Hand Finishing

150 QC5- Inspect part completeness to step on W/O 0.00

150

QC Memo 0.00

Quality Control

ent 11/12/10

4

4x0 m 11/12/12

Q3

Memo

chemical conversion

Sultra

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 77092

77092

Page 3

November-25-11 10:54:31 AM

Item ID: D3606-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cuff

Start Date: 25/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>480</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/12/22 *[Signature]*
 MF
 11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-25-11 10:54:36 AM

Page 1

Work Order ID: 77092

77092

Parent Item: D3606-1

D3606-1

Parent Item Name: Cuff

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A new issue EC
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129P		Purchased	No			100	Each	0.0000	0.6603	2.527579			

D6009-129P

Crosstube Material

65/79

Re-191 material

W/O:		WORK ORDER CHANGES					
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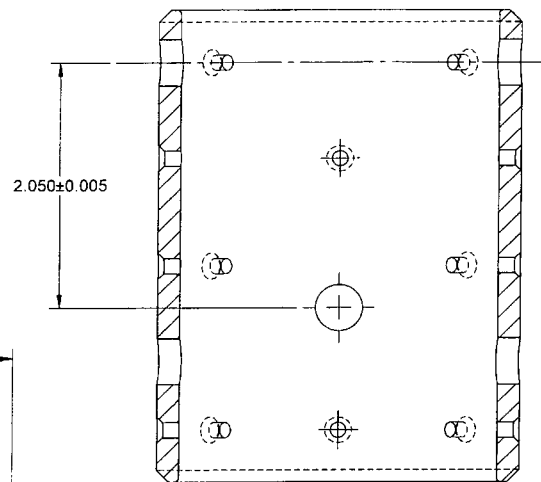
NOTE: Date & initial all entries

153606

X	First Article		Prototype
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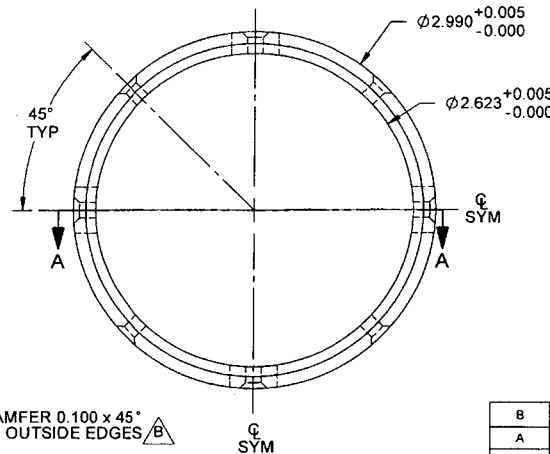
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/12/9	Date:	11/12/10	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD



R0.032 TYP
INSIDE EDGES

SECTION A-A



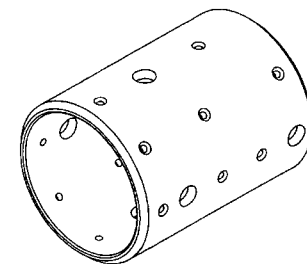
CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3606-1 CUFF

DRILL #30 (Ø0.128 REF)
C'SINK Ø0.230X100°
TYP 22 PLACES

Ø0.386^{+0.005}
-0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF.
TYP 6 PLACES

- NOTES:**
- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77092 H.L.J.
11/11/25

B	REFORMAT DWG. ADD Ø0.128 & Ø0.386 HOLES (B8), ALL OUTER EDGES NOW CHAMFERED (A5)	CP	08.03.03
A	NEW ISSUE	CP	07.03.01
REV	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	CP		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP		
DATE	08.03.03		
<p>DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</p> <p>DRAWING NO. D3606 REV. B</p> <p>TITLE CUFF SCALE NTS</p> <p>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</p>			

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